

Slip 30.31/101

Date: Thursday, 25/10/2007 2:34:57 PM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : STEP WELDMENT
<b>Job Number</b> : 35401	
<b>Estimate Number</b> : 12576	
<b>P.O. Number</b> :	<b>Part Number</b> : D3562041
<b>This Issue</b> : 25/10/2007 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3562 UNDER REVIEW
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 1/1 <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 35262	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 01/11/2007 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est Rev:A New Issue 06-11-09 JLM Est rev B ECN 987 07.10.09 EC verified by: DD	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D2622120C	Extrusion
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	B34694

Check Material for any Dents or Defects

SE 01.10.25

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

SE 01.10.25

SE 07.10.25

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

SE 07.10.26

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SE 07.10.26

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: STEP WELDMENT

Job Number: 35401

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/10/27

6.0

D3560041

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
ARM WELDMENT 334474

07.10.27

7.0

D3560043

ARM WELDMENT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
ARM WELDMENT  
Batch: 334476

07.10.27

8.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total : 36.0000 Each(s)  
Blind Rivet  
batch: 05125

07.10.27

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Transfer drill Rivet holes as per dwg D3562.

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Magnabond as per dwg D3562.

\*\*\*\*\*Ensure to wipe off any excess magnabond \*\*\*\*\*

A/R Magnabond 6398 Batch: 104677

07.10.27

07.10.27

07.10.27

07.10.27

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/27

PTO

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-10-30	17A	Install bushing D2808 #B <u>32896</u>	mf	07-10-30	2		
07/10/30	17B	inspect Qc level 25	S	07/10/30	(1)		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: STEP WELDMENT

Job Number: 35401

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2734

206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2734

End Cap 3.34485

*Handwritten:* 07.10.29 (1)

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod M105058

2-Grind end cap welds flush as per Dwg D3562

*Handwritten:* 07.10.29 1  
07.10.29 1

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*Handwritten:* 07.10.29 (1)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* 07.10.30

15.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*Handwritten:* 1) TOUCH-UP END-CAPS

*Handwritten:* M105914

*Handwritten:* 07-10-30 (1)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: M106030

*Handwritten:* M-4 07/10/30

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Handwritten:* MF 07-10-30

**Dart Aerospace Ltd**

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

*07.10.31* (1)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



*07.10.31*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*07.10.31*

W/O:		WORK ORDER CHANGES					
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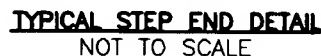


**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA





**UNDER REVIEW**

07.10.22 DC

403540



- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 3) WELD PER DART QSI 004
- 4) FINISH:
  - i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY
  - ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3. TOUCH UP ANY UNFINISHED MAGNOBOND WITH PAINT PER DART QSI 005 4.2
  - iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 5) ALL DIMENSIONS ARE IN INCHES

DESIGN		DRAWN BY		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. C
				D3562	SHEET 1 OF 1
DATE				TITLE	SCALE
07.06.19				STEP ASSEMBLY	NTS
A	06.09.26			NEW ISSUE	
B	07.01.15			ARMS NOW RIVETED TO STEP	
C	07.06.19			NOW MAGBND, ADD D2808, RMV 4 RVTs	

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